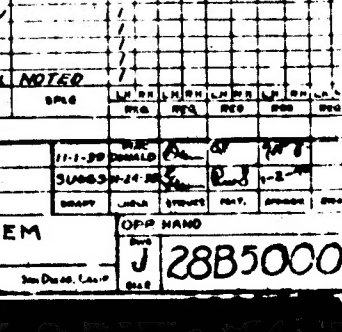
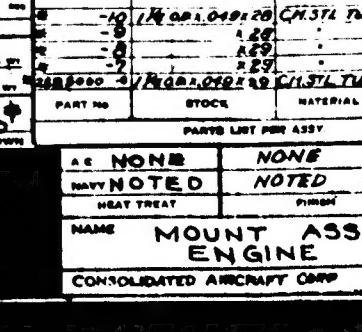
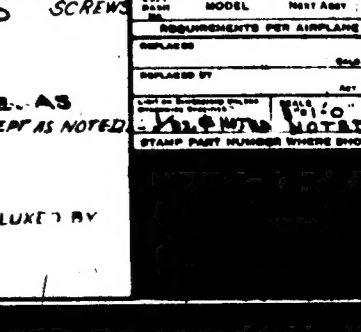
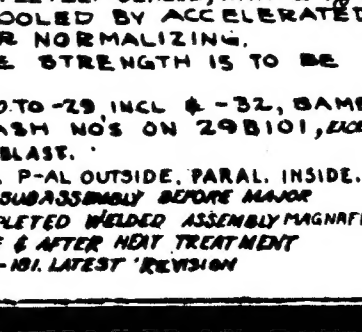
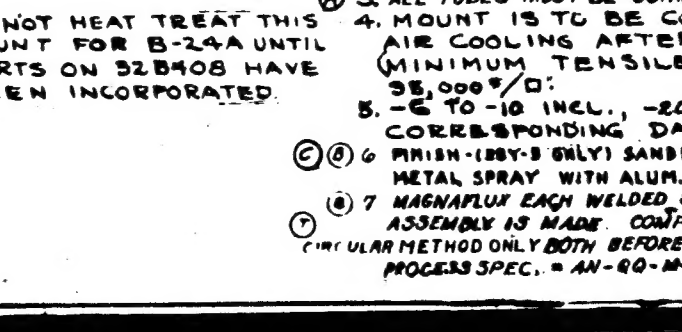
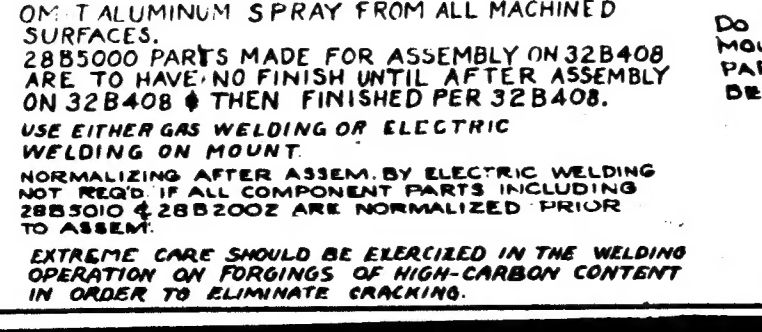
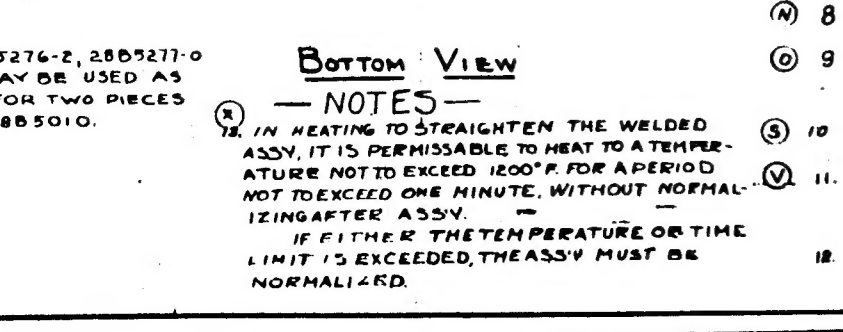
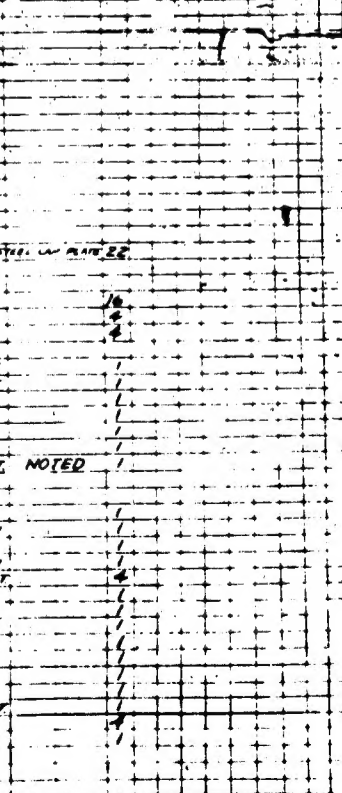
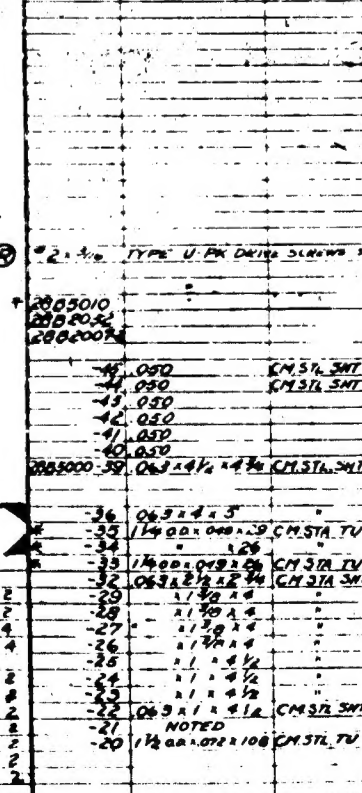
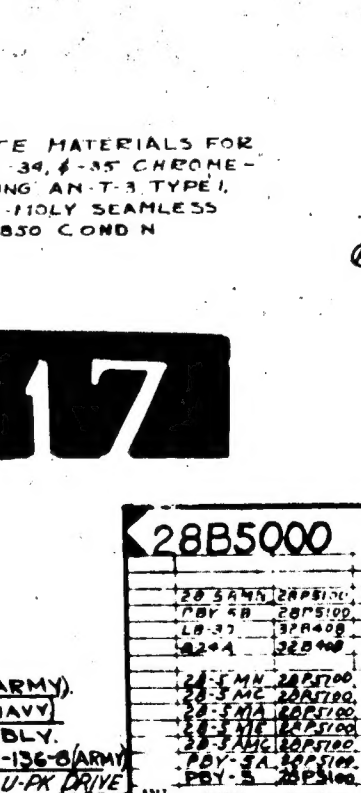
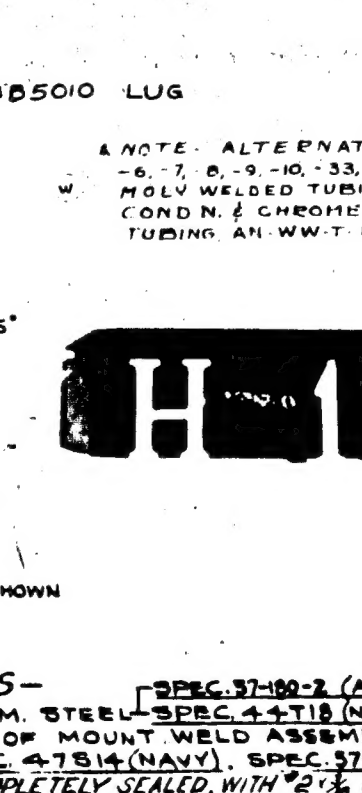
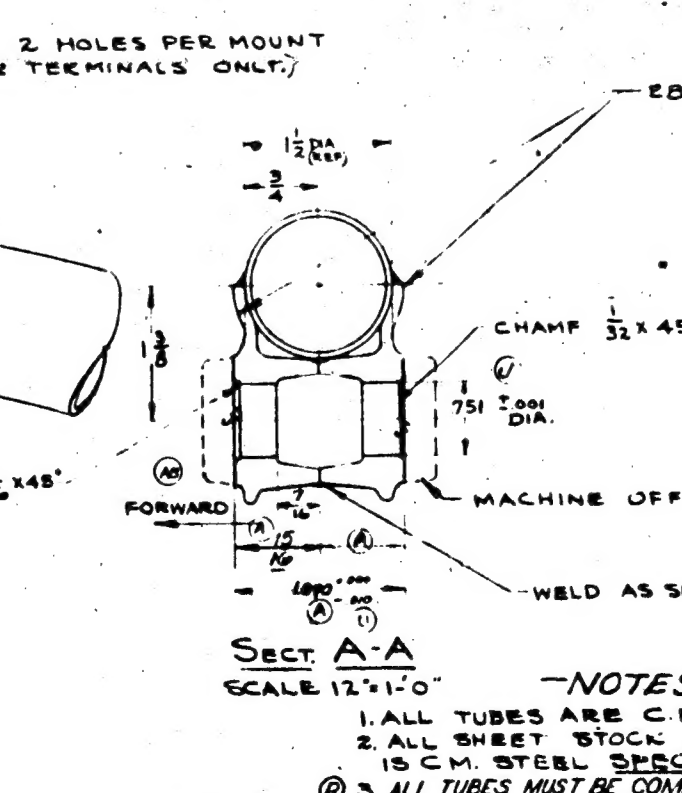
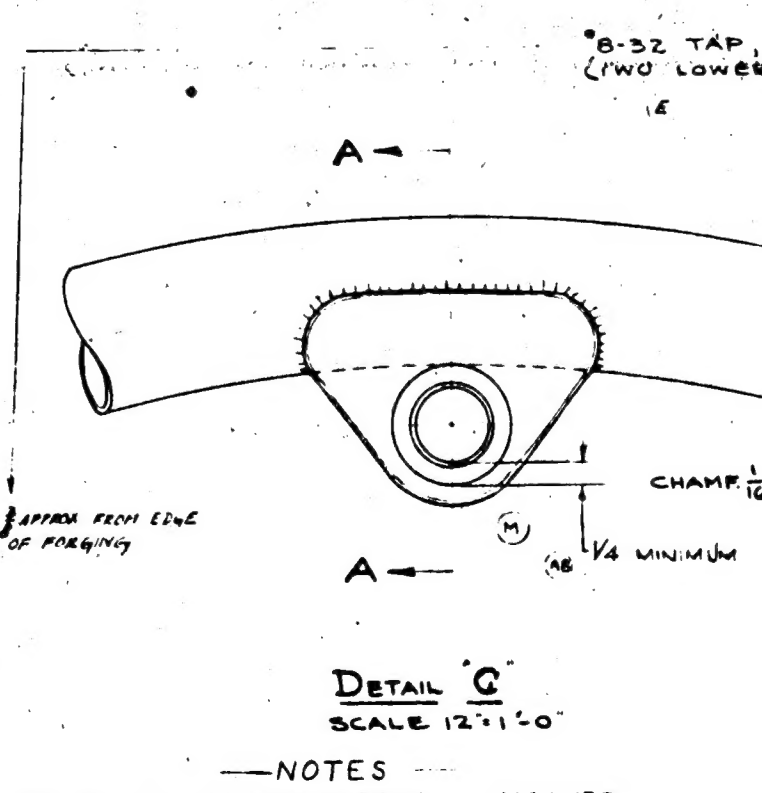
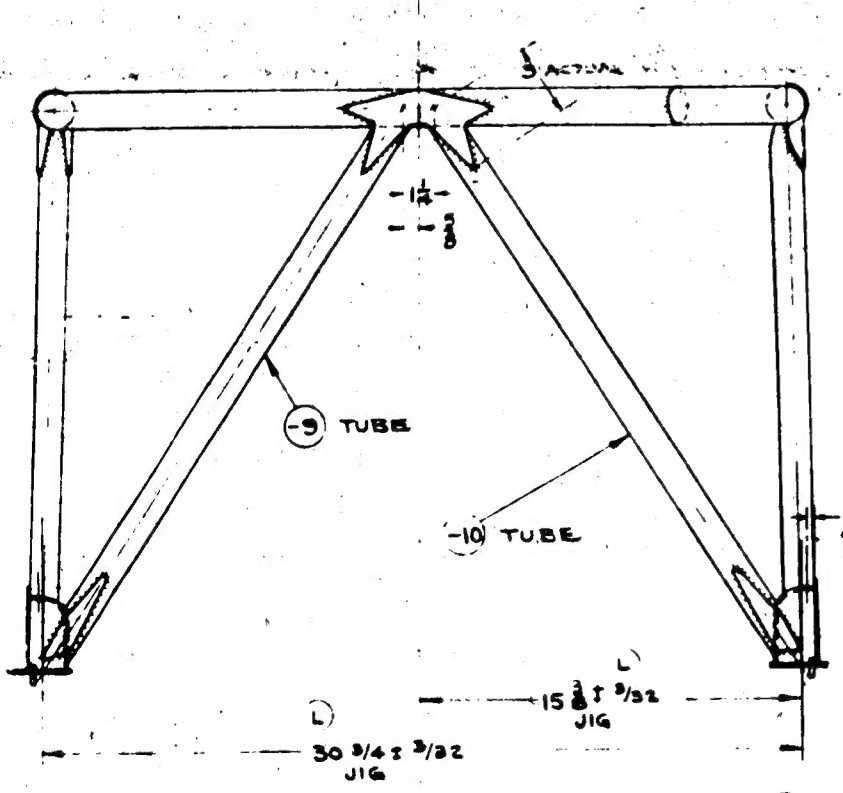
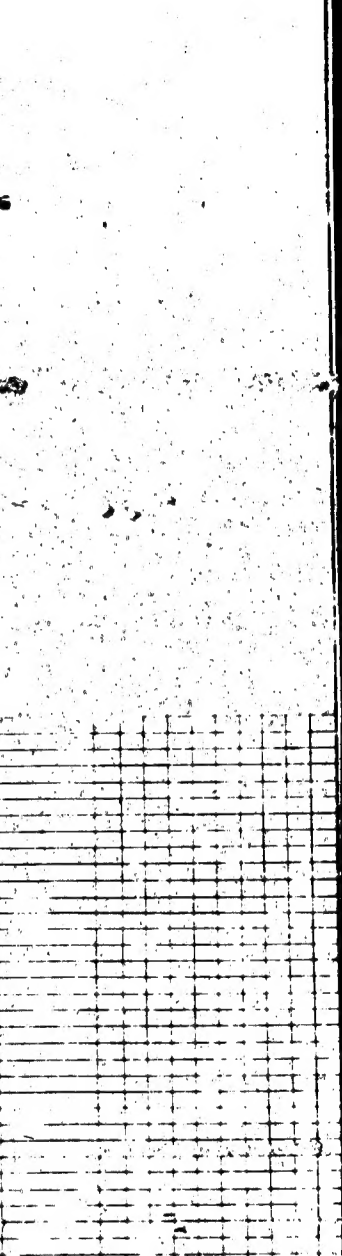
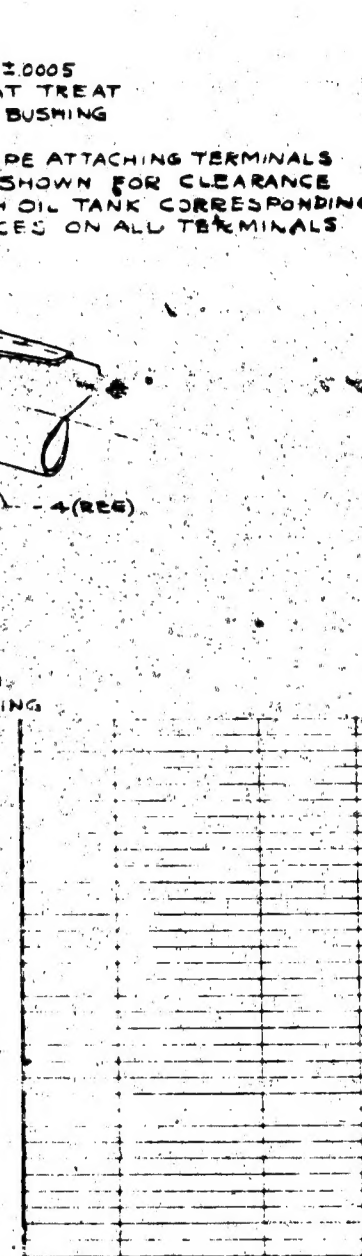
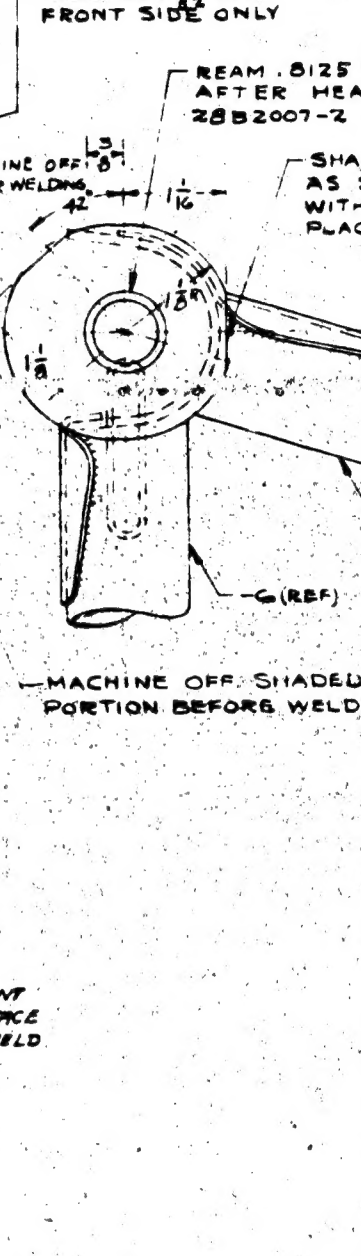
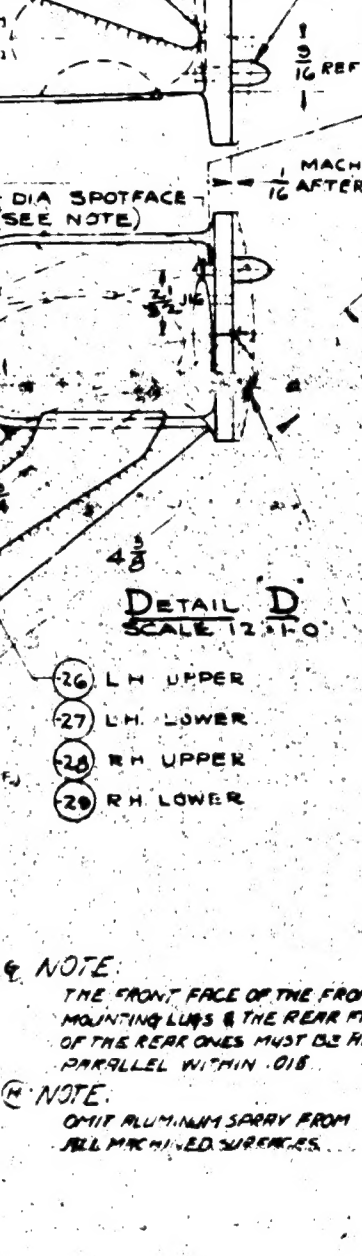
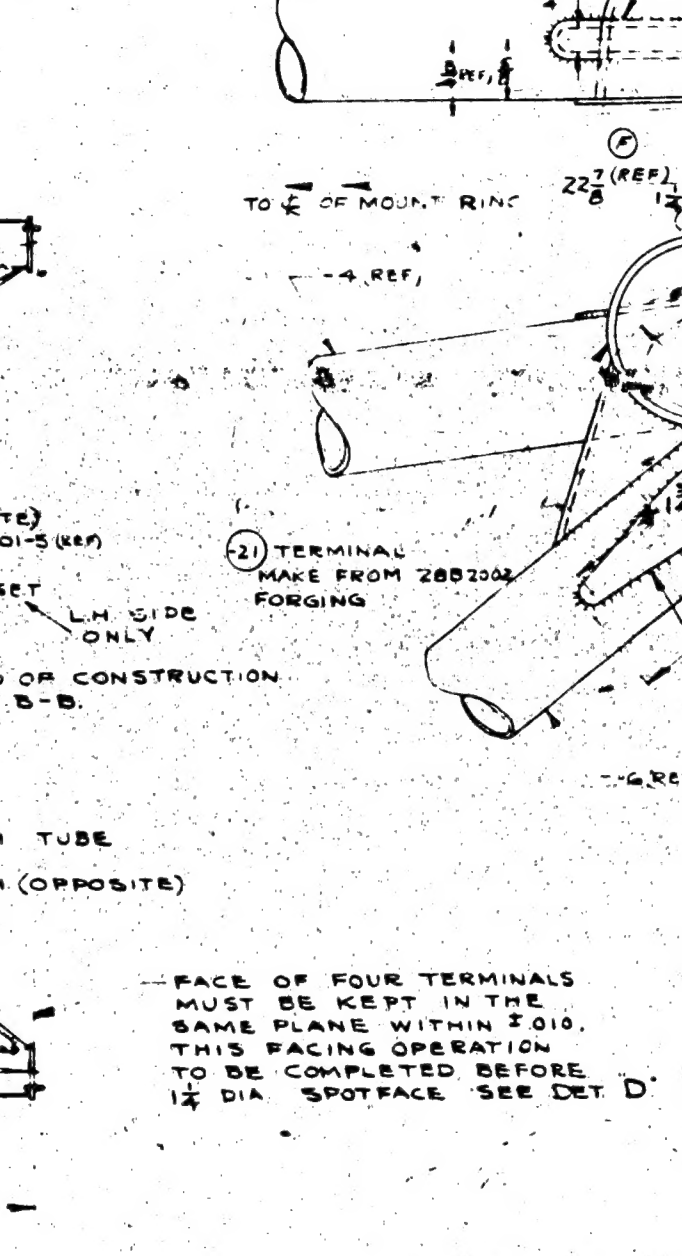
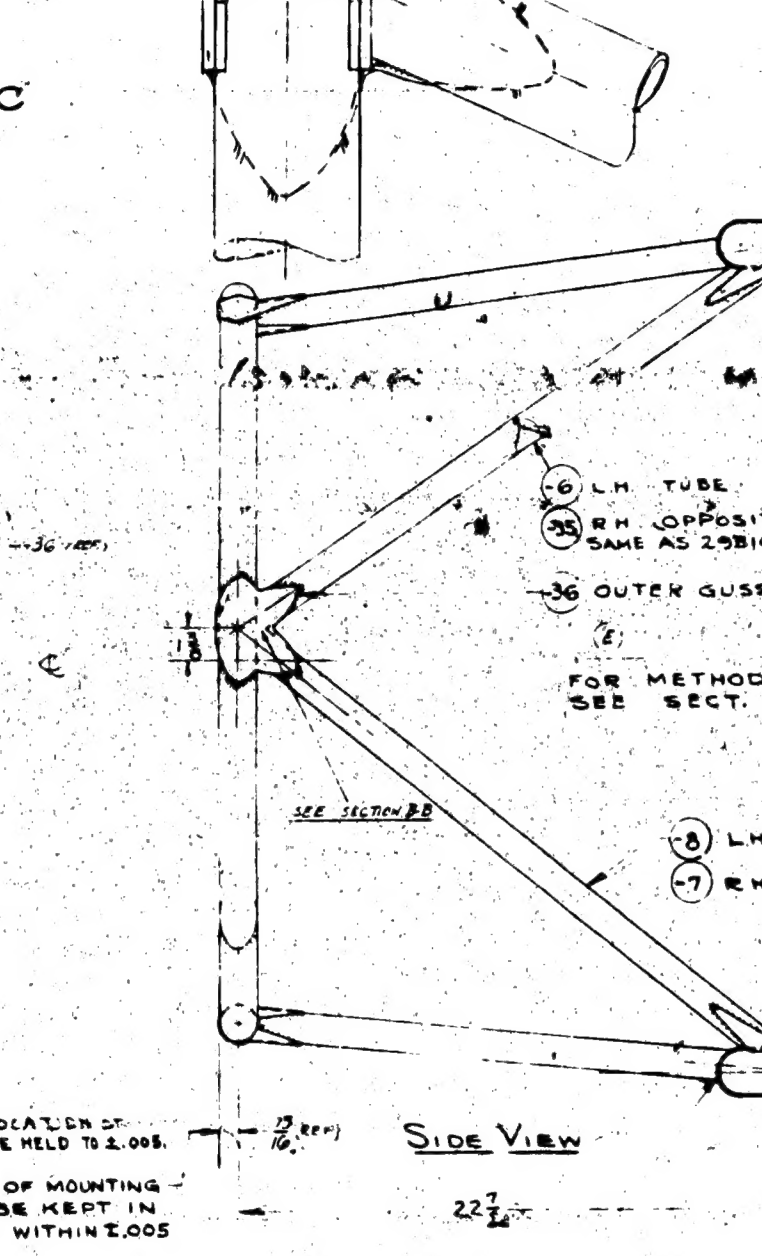
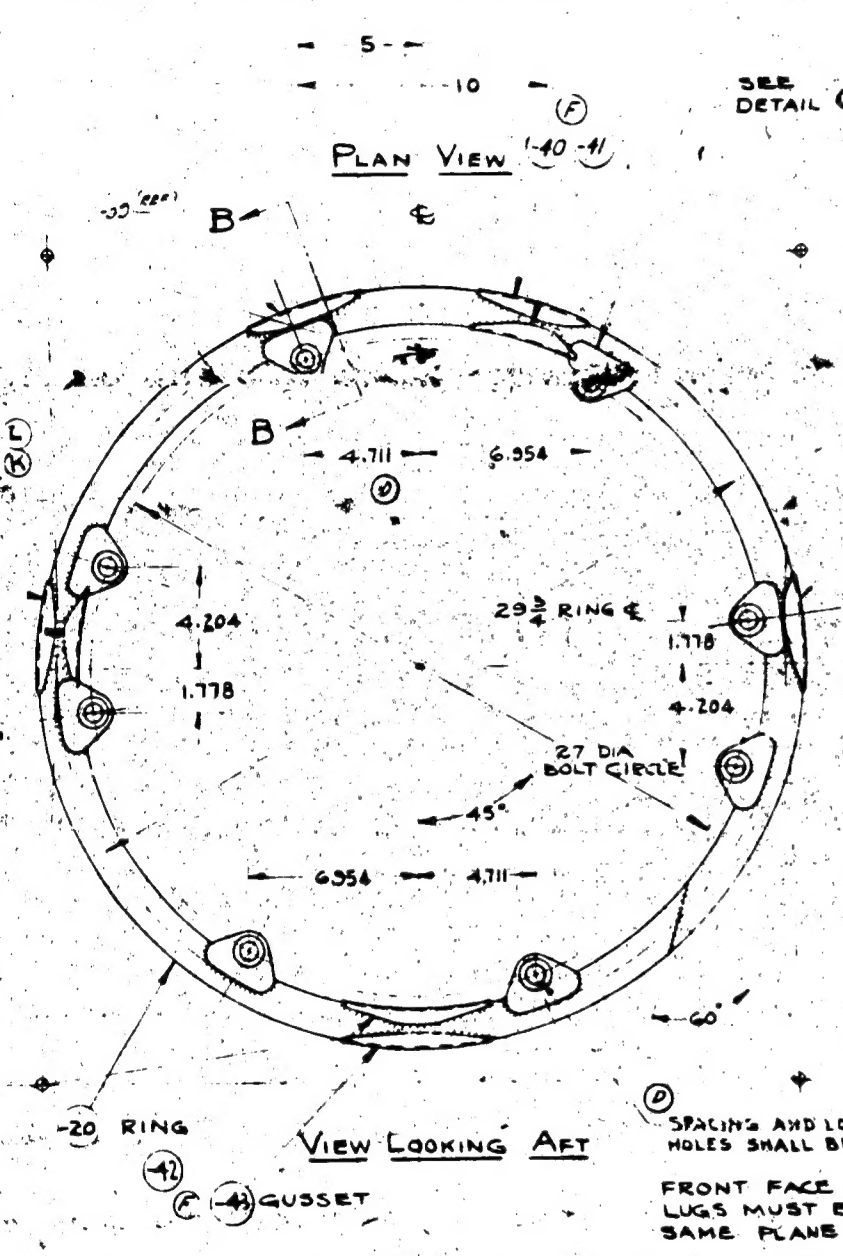
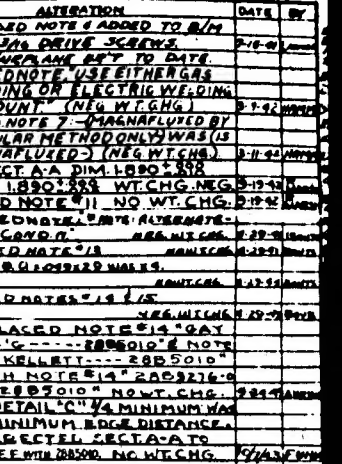
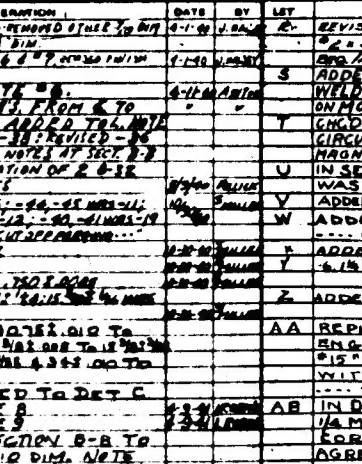
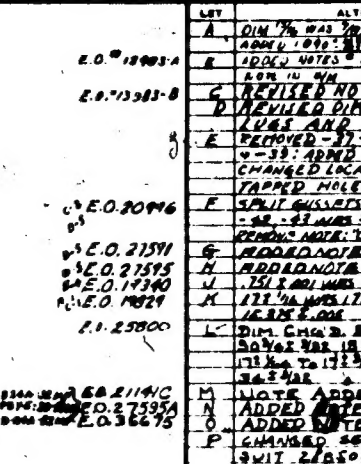
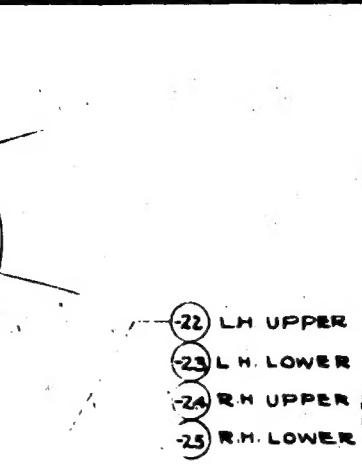
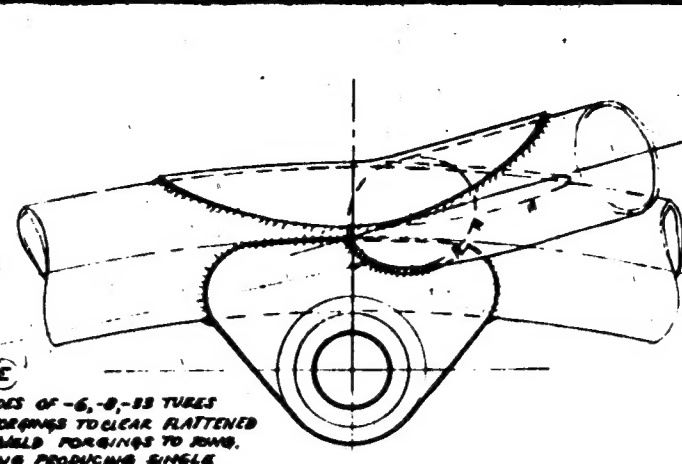
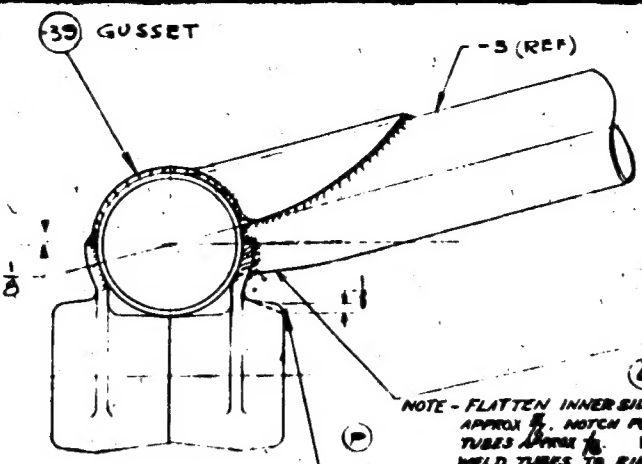
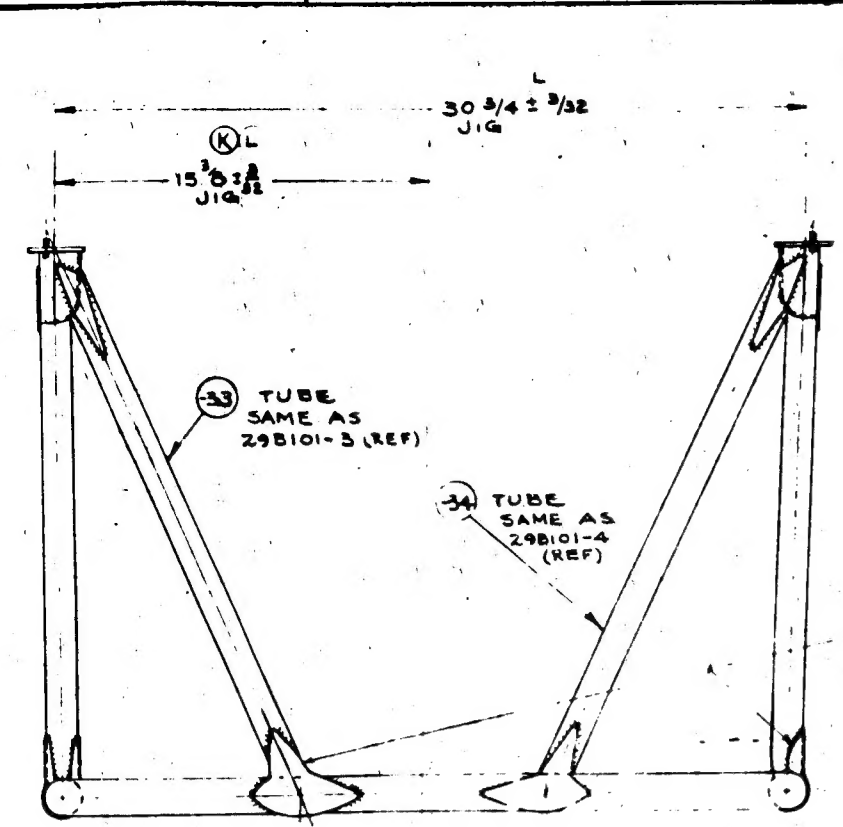


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15. 28B5276-0, 28B5276-2, 28B5277-0 OR 28B5277-2 MAY BE USED AS ALTERNATES FOR TWO PIECES OF FORGING 28B5010.

### NOTES

- IN HEATING TO STRAIGHTEN THE WELDED ASSY, IT IS PERMISSIBLE TO HEAT TO A TEMPERATURE NOT TO EXCEED 1200°F FOR A PERIOD NOT TO EXCEED ONE MINUTE, WITHOUT NORMALIZING AFTER ASSY.
- IF EITHER THE TEMPERATURE OR TIME LIMIT IS EXCEEDED, THE ASSY MUST BE NORMALIZED.

- ON T ALUMINUM SPRAY FROM ALL MACHINED SURFACES.
- 28B5000 PARTS MADE FOR ASSEMBLY ON 32B408 ARE TO HAVE NO FINISH UNTIL AFTER ASSEMBLY ON 32B408 & THEN FINISHED PER 32B408.
- USE EITHER GAS WELDING OR ELECTRIC WELDING ON MOUNT.
- NORMALIZING AFTER ASSEM. BY ELECTRIC WELDING NOT REQD. IF ALL COMPONENT PARTS INCLUDING 28B5010 & 28B2002 ARE NORMALIZED PRIOR TO ASSEM.
- EXTREME CARE SHOULD BE EXERCISED IN THE WELDING OPERATION ON FORGINGS OF HIGH-CARBON CONTENT IN ORDER TO ELIMINATE CRACKING.

DO NOT HEAT TREAT THIS MOUNT FOR B-24A UNTIL PARTS ON 32B408 HAVE BEEN INCORPORATED.

- ALL TUBES ARE C.M. STEEL SPEC. 4-118 (NAVY).
- ALL SHEET STOCK OF MOUNT WELD ASSEMBLY IS C.M. STEEL SPEC. 4-7814 (NAVY).
- ALL TUBES MUST BE COMPLETELY SEALED WITH 2% U-PX DRIVE.
- MOUNT IS TO BE COOLED BY ACCELERATED AIR COOLING AFTER NORMALIZING.
- MINIMUM TENSILE STRENGTH IS TO BE 35,000 PSI.
- 6 TO 10 INCL., -20 TO -29 INCL. & -32, SAME AS CORRESPONDING DASH NOS ON 29B101, EXCEPT AS NOTED.
- FINISH (B-10) & (B-11) SANDBLAST.
- METAL SPRAY WITH ALUM. P-A OUTSIDE, PARAL. INSIDE.
- MAGNETIC FLUX EACH WELDED SUBASSEMBLY BEFORE MAJOR ASSEMBLY IS MADE.
- COMPLETED WELDED ASSEMBLY MAGNETIC FLUX BY CIRCULAR METHOD ONLY BOTH BEFORE & AFTER HEAT TREATMENT PROCESS SPEC. - AN-80-M-181 LATEST REVISION.

# H-17

### 28B5000

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